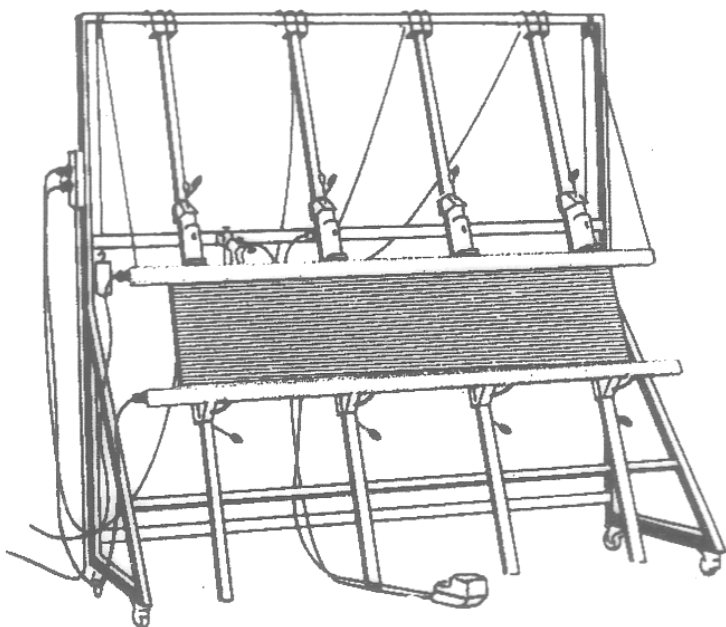

OBLAGANJE UŽIH STRANA PLOČA

POSTUPCI OPLEMENJAVANJA

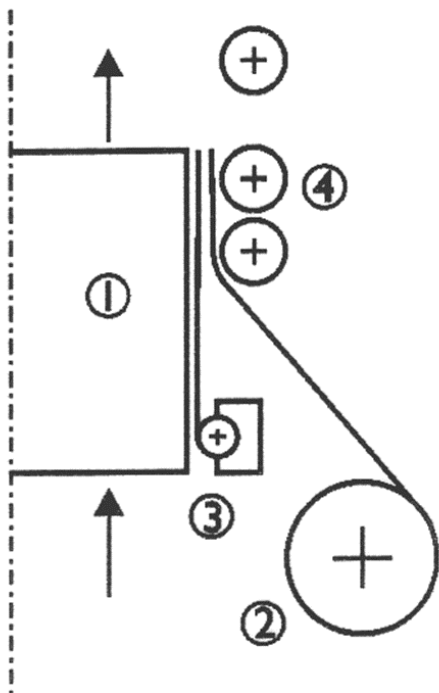
Način oplemenjivanja	Materijal za oplemenjavanje					Lepak
	FURNIR	PVC traka	ABS traka	LAMINAT	MASIV	
HH	+	+	+	+	+	PVA-c; neoprenski
VH	+	+	+	+	+	EVA
VHR	+	+	+	+	-	EVA Nanet u procesu proizvodnje rubnog materijala
HV	+	+	+	+	-	Modifikovani PVA-c PU
HA	+	+	+	+	-	Modifikovani PVA-c
Softforming	+	+	-	+	-	EVA
Postforming	-	-	-	+	-	PVA-c

HH POSTUPAK



Lepak	Materijal za opleminjavanje
PVA-c	Furnir, masiv,
neoprenski	Furnir, masiv, laminat, PVC traka, ABS traka
$t(^{\circ}\text{C})$	20 ± 2
$Q(\text{g}/\text{m}^2)$	150 ± 20

VH POSTUPAK



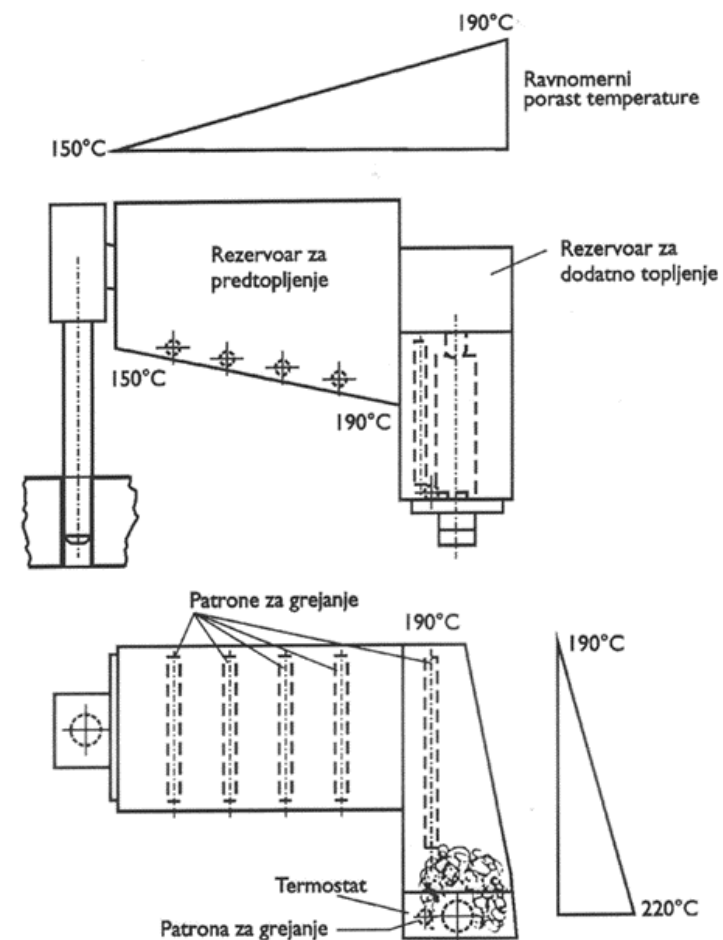
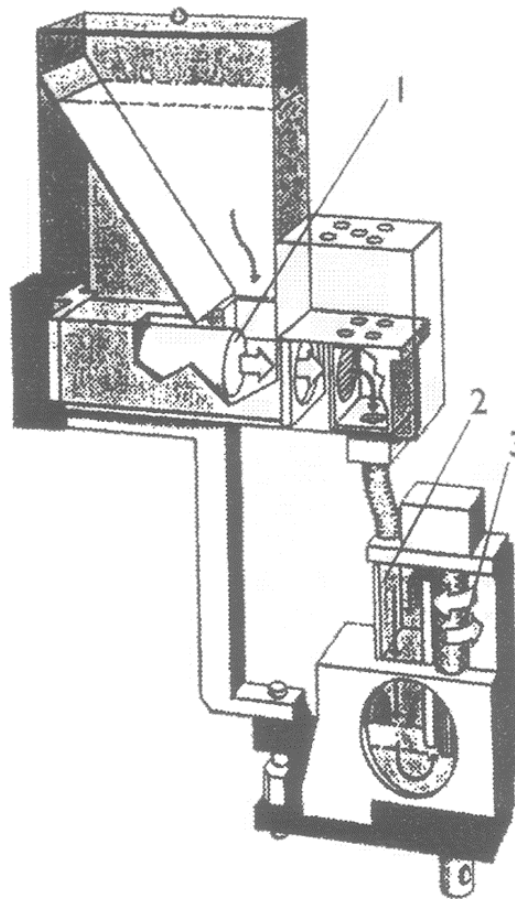
Lepak	Materijal za opleminjavanje
EVA	Furnir, masiv, laminat, PVC traka, ABS traka
t(°C)	190÷220
Q(g/m ²)	150±20

VH POSTUPAK

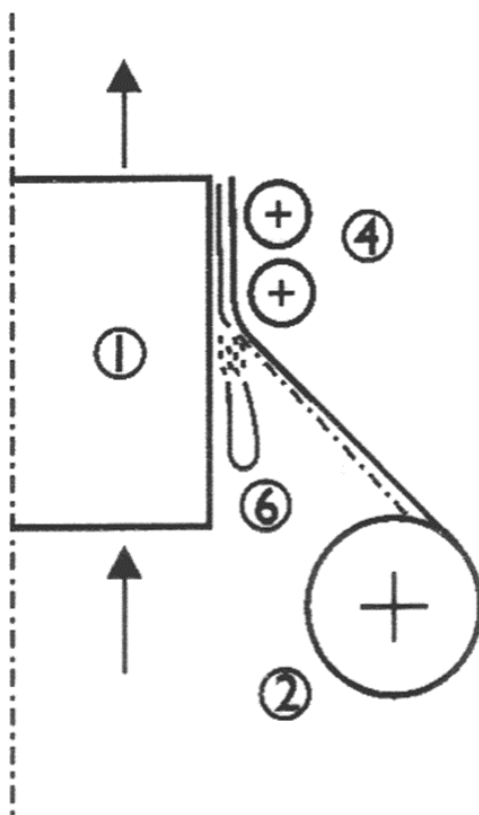
■ TOPLJENJE EVA LEPKA pri VH postupku

Karakteristike:

Osnova lepka	Etilen-vinil acetat copolimer (EVA)
Viskozitet	Priblizno 80.000 mPa.s Brookfield RTV , vreteno SC4-29 pri 204 oC
Tacka omeksavanja	Pri 100 oC , Ring and Ball u skladu sa ASTM E 28
Temperatura pri upotrebi	Temperatura prostora i materijala od 18 do 20 oC
Vlaznost drveta	od 8 do 10%
Radna temperatura na valjku	190 do 210 oC
Brzina pomaka	najmanje 20 m/min.

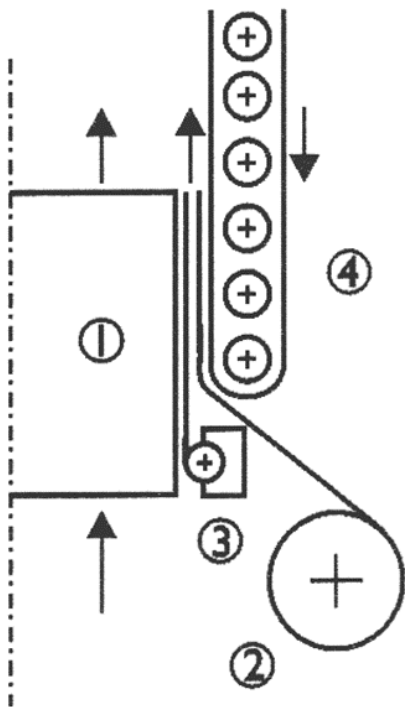


VHR POSTUPAK



Lepak	Materijal za opleminjavanje
EVA Nanet u procesu proizvodnje rubnog materijala	Furnir, PVC traka, ABS traka
$t(^{\circ}\text{C})$	190÷220
$Q(\text{g}/\text{m}^2)$	80÷120

HV POSTUPAK



Lepak	Materijal za opleminjavanje
Modifikovani PVA-c PU	Furnir, PVC traka, ABS traka
t(°C)	190÷220
Q(g/m ²)	150±20

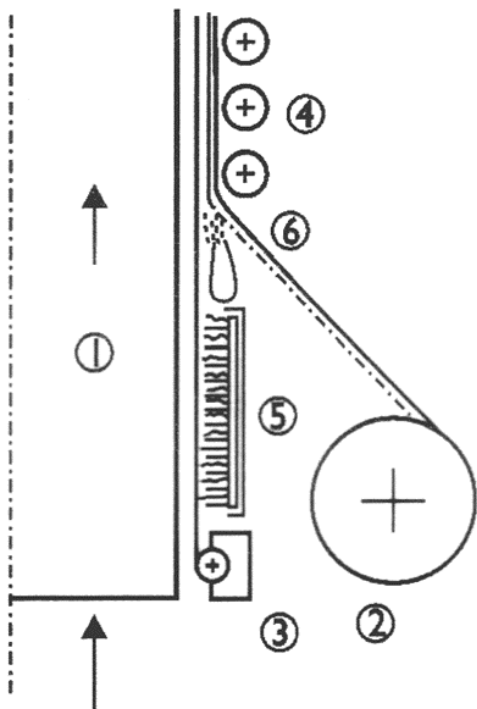
KLEIBERIT 707.7 - PUR HOTMELT ADHESIVE CARTRIDGES

FEATURES

PACKAGING

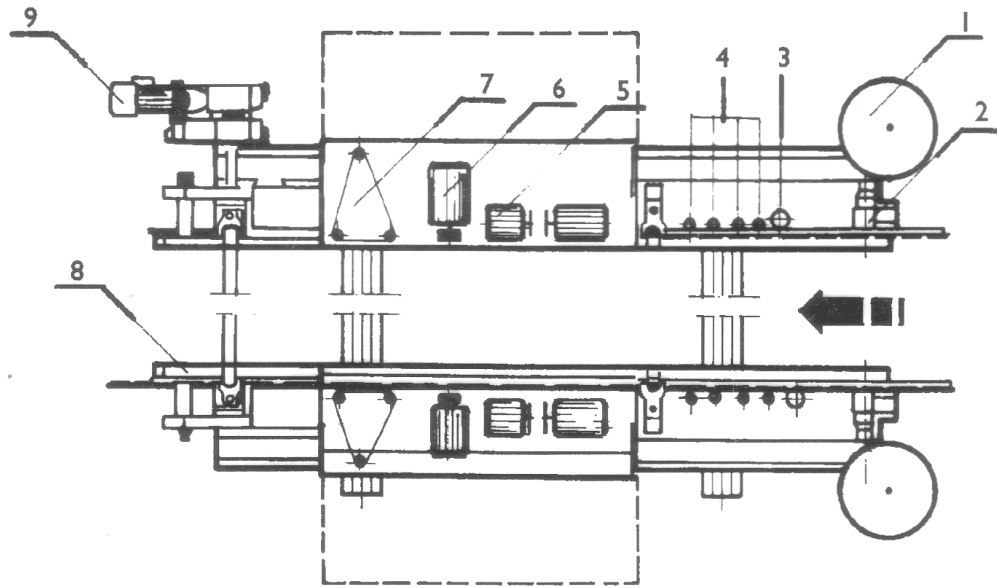
- Made In Germany
- Reactive PUR hotmelt adhesive for highly durable edge bonds processed on HOLZ-HER edgebanding machines with the cartridge system
- Exterior use - Optimal adhesive protection from moisture (D4 Classification)
- Application Temp: 120°C to 150°C
- Temperature resistance from -30°C to 150°C
- Sold Per Box of 6 x Aluminium Cans - 1.44kg
- Clean up will need to be mechanical means after cure - ABS Cleaner will soften but not dissolve this adhesive
- For more information refer to the technical data sheet
- To clean your edgebanding machine - see below SM761.0 Cleaning Cartridge
- Colour: White Opaque

HA POSTUPAK

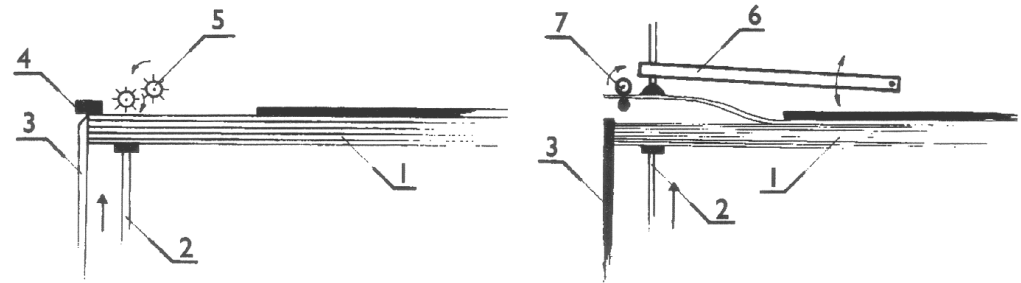


Lepak	Materijal za opleminjavanje
Modifikovani PVA-c +EVA	Furnir, PVC traka, ABS traka
t(°C)	190÷220
Q(g/m ²)	80 +120±20

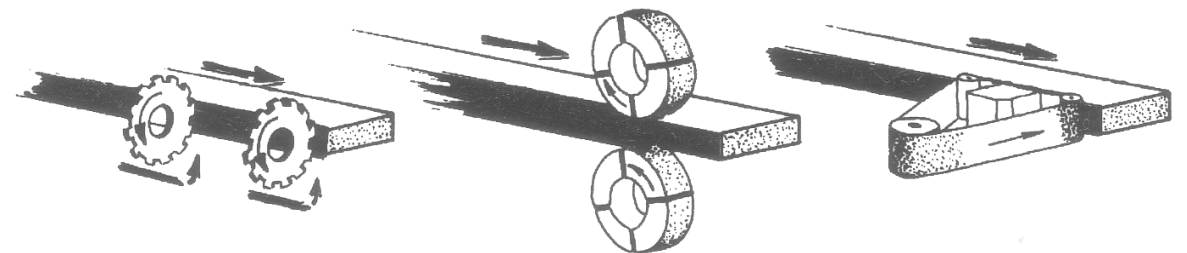
DELOVI KANT MAŠINE



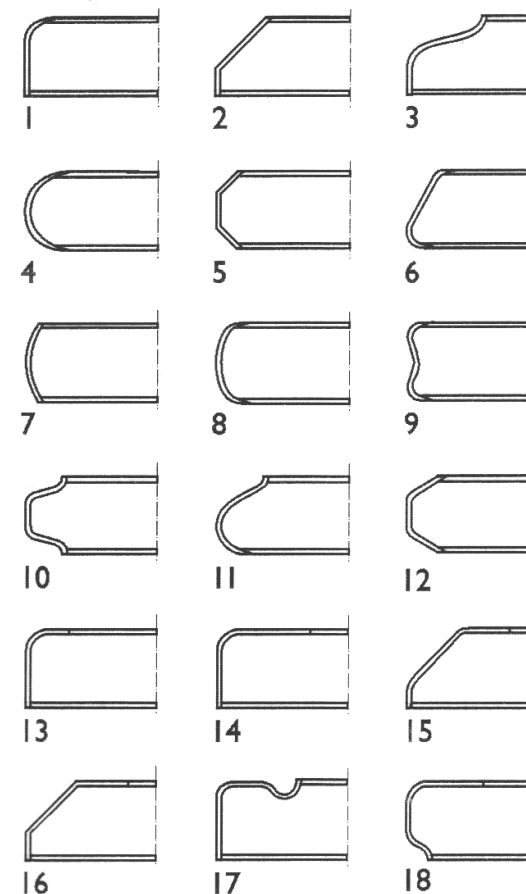
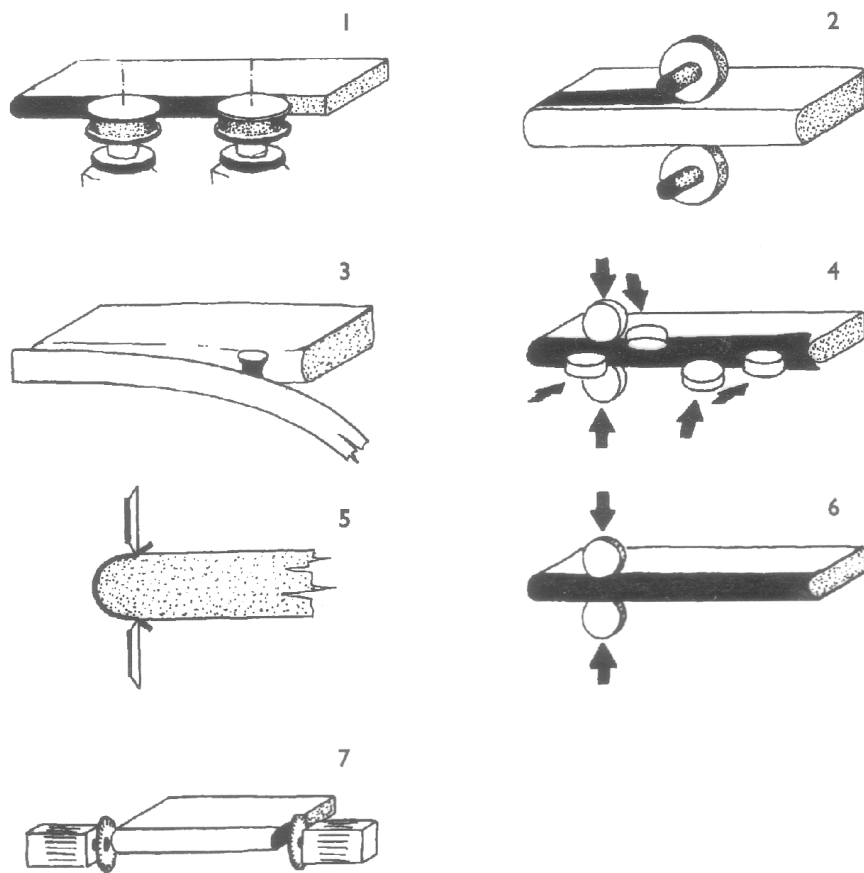
■ DOZIRANJE RUBNOG MATERIJALA



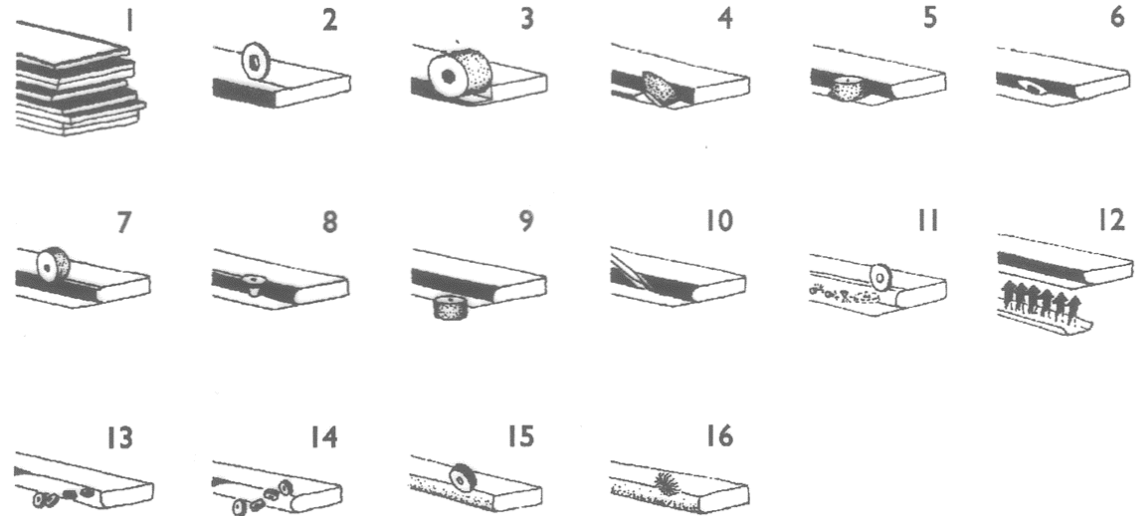
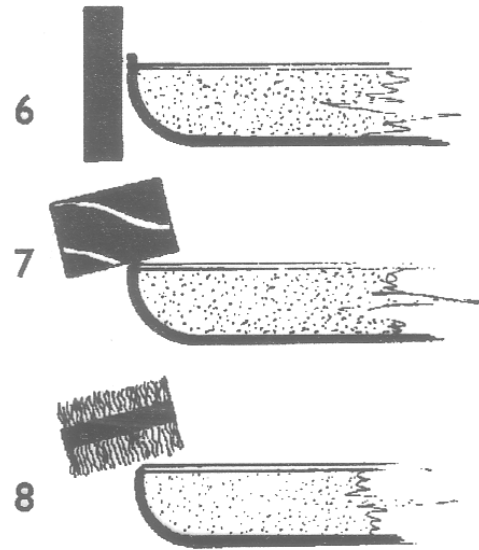
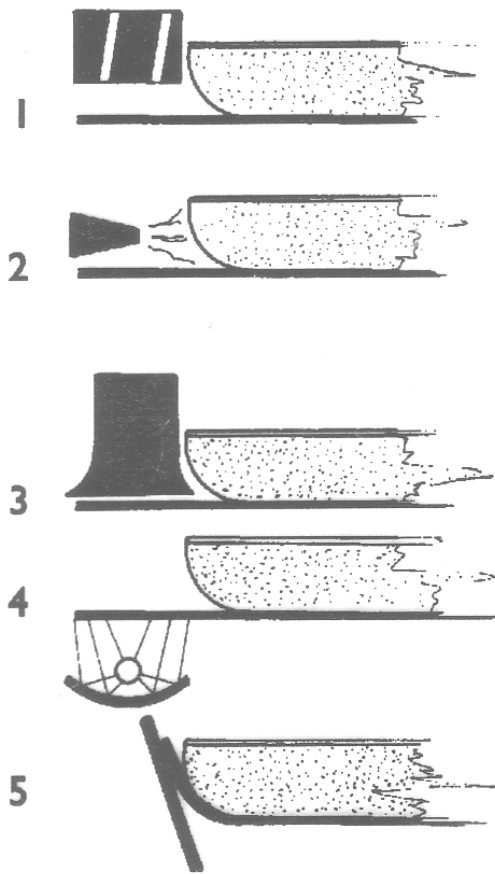
■ OBRADA RUBNOG MATERIJALA



OPLEMENJIVANJE PROFILISANIH RUBOVA PLOČA SA PRAVOLINIJSKIM KONTURAMA – SOFTFORMING POSTUPAK



OBLAGANJE USKIH PROFILISANIH POVRŠINA- POSTFORMING POSTUPAK



OBLAGANJE USKIH PROFILISANIH POVRŠINA- POSTFORMING POSTUPAK

- Rakoll HP / 2A se upotrebljava kod postforming masina Homag i masina kod kojih je nanosenje lepka pistoljima.

Karakteristike:

Osnova lepka	PVAc - disperzija
Boja:	bela , kada se osusi transparentna.
PH vrednost:	priblizno 4,5
Viskozitet:	priblizno 8.000 mPas/Brookfield HBT , 20 RPM
Kriticna tacka:	+ 3o C
Brzina nanosenja:	6 do 8 min
Temperatura pri ventiliranju vrelim vazduhom:	300 do 400 o C
vlaznost grejaca:	90 do 100%
Otpornost zalepljenih spojeva:	B 2 po DIN 68.602
Ponasanje na hladnoci:	osetljiv na mraz
Skladistenje:	U dobro zatvorenim originalnim posudama do 6 meseci.